

# Work Order ID 62920

Wednesday, October 13, 2010 12:59:18 PM



Page 1

Item ID:	D3475-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Tube				Stop	
Start Date:	10/14/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	10/20/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>10-10-13</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3475	Rev C

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per Dwg D3475								
<u>304</u> <u>1018</u>	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								

18 10-10-14

(3)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

18 10-10-14

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

3

10/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62920

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Item ID: D3475-3

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 10/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Memo

0.00

=> m-l 10/10/18

3x

Small Fab

1-Roll as per Dwg D3475  
2-Bead as per Dwg D3475  
3-Spot Weld as per Dwg D3475

140



QC

Quality Control

QC11- Inspect spot weld per QSI004

Memo

0.00

SB 10/10/18

3

150



Packaging

Packaging

Identify as per dwg & Stock Location:

GA

w/ 62918

0.00

SB 10/20/18

3

Memo

0.00

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 62920**

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Item ID: D3475-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 10/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 J  
MF  
10-10-18

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 62920

Parent Item: D3475-3

Parent Item Name: Tube




Start Date: 10/14/2010

Required Date: 10/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-03 JLM  
IPP Rev:B As per Rev B 06-05-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			100	sf	144.0000	0.12	0.24	.36		

1810-10-14

Location

Loc Qty

Loc Code

MAT20

144

109398

48

112885

96

109398

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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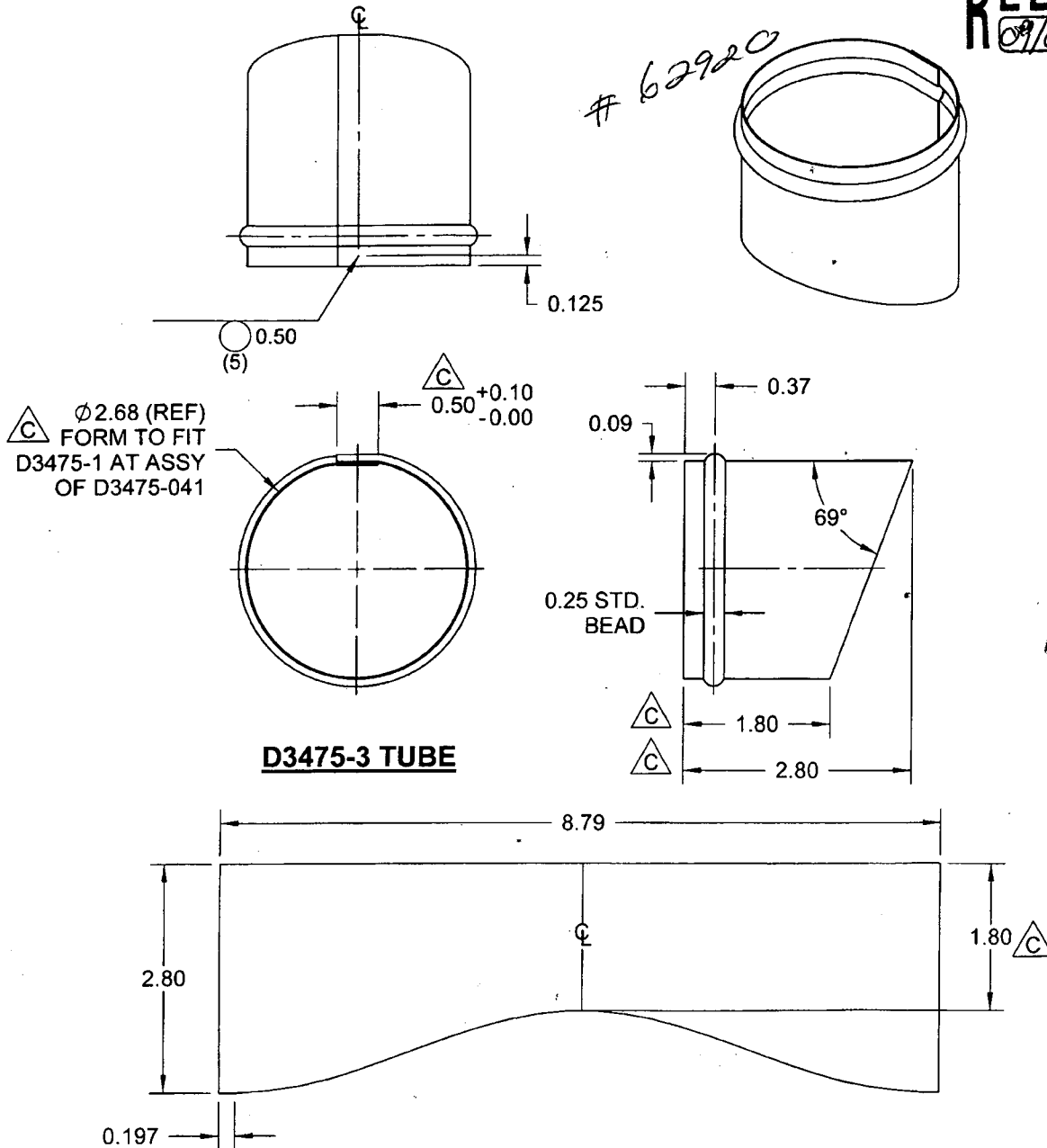
**NOTE:** Date & initial all entries





**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3475</b>	REV. C SHEET 3 OF 7
DATE <b>08.12.19</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:2

**RELEASED**  
09/01/20 MP**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle C$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTE: Date & initial all entries

# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 51

EMPLOYEE: Marc Gregory

PART NUMBER: D3475-3

JOB NUMBER: B 62920

MATERIAL TYPE: 304

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <u>/</u> ]	[   ]
PENETRATION:	[ <u>/</u> ]	[   ]
PULL STRENGTH:	[ <u>/</u> ]	[   ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 10/12/18

QUALIFIER: SB

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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